

Date: Thursday, 2/23/2006 10:23:14 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE
 Job Number : 25914
 Estimate Number : 10314
 P.O. Number : N/A Part Number : D265613
 This Issue : 2/23/2006 S.O. No. : N/A Drawing Number : D2656 REV D
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : D
 Previous Run : 25329 Material : N/A
 Due Date : 3/22/2006 Qty: 50 Um: Each
 Written By : *SEE COMMENT BELOW*
 Checked & Approved By : *06.02.23*
 Comment : Est: F 02.10.25 Re-format KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

PG

PURCHASING



Comment: PURCHASING

Issue P/O: *00000659*

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-13

3-Material release note required

AP
06/02/24

2.0

D265613F

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 WEAR PLATE

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material release note is attached

C206103109 (50)

4.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-13T1

06.03.15

50

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

N/A *SP 02/03/16 50*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 06/03/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Thursday, 2/23/2006 10:23:14 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 25914

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

SB 06/03/16 50

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-03-16 50

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4:3

DL 06/03/20 50

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ml 06 03 21 50

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: F.P.

ml 06 03 21 50

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/03/21 50

Job Completion



u 06-03-21

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

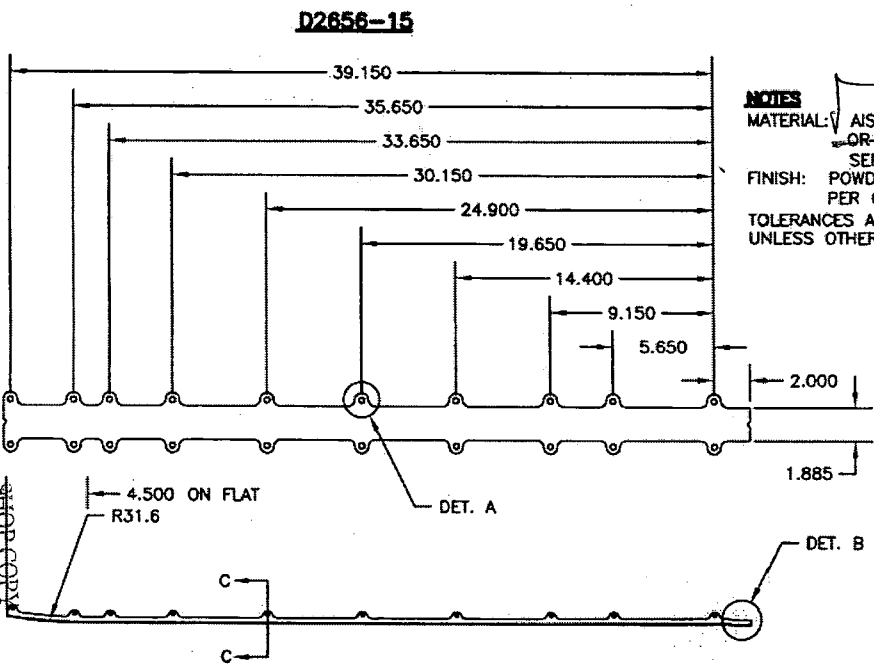
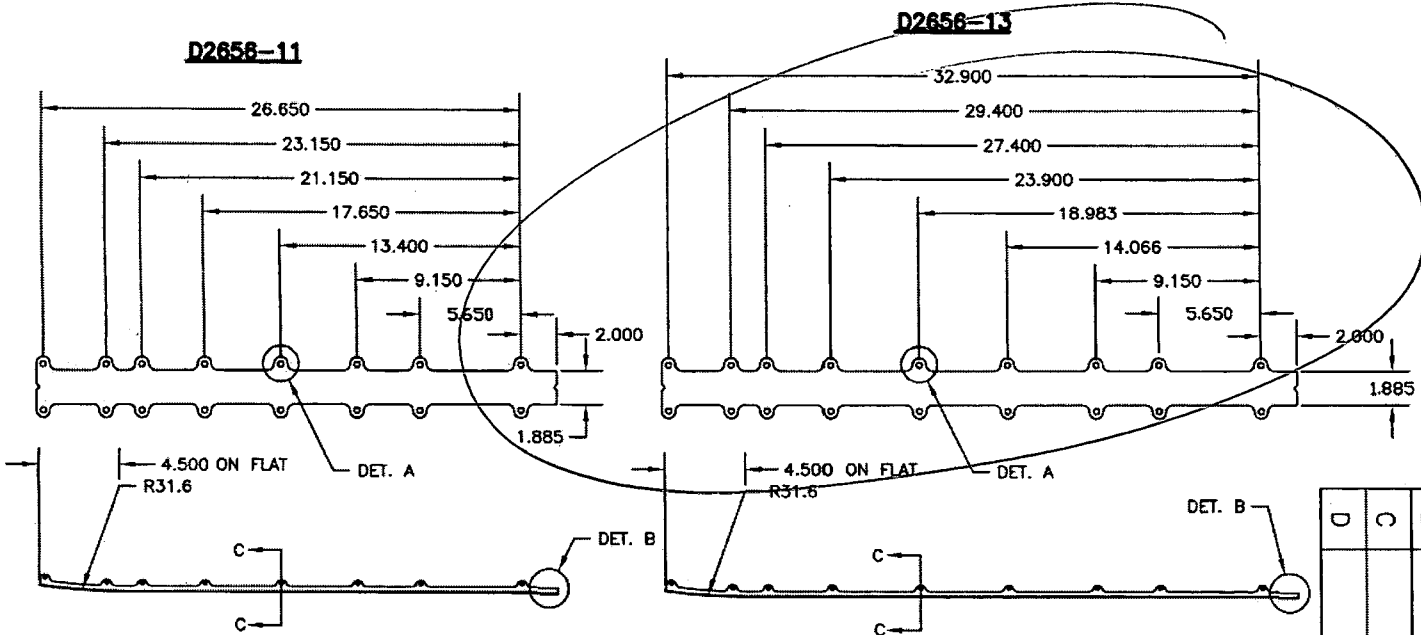
QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	DS	DRAWN BY	CP	DART AEROSPACE USA, INC.	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO.	REV. D
DATE	05.08.17			D2656	SHEET 1 OF 4
				TITLE	SCALE
				WEARSHOE	1:10
A		97:03:25	NEW ISSUE		
B		97:06:02	CHANGED TABS		
C		97:06:26	R31.6 WAS R19.5		
D		05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		



MATERIAL: ~~AS1 1010-1025 OR ASTM A36/A366/A1008~~
~~OR-ESA G40-21, 38W/44W/50W/60W/70W~~
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

05-09-08

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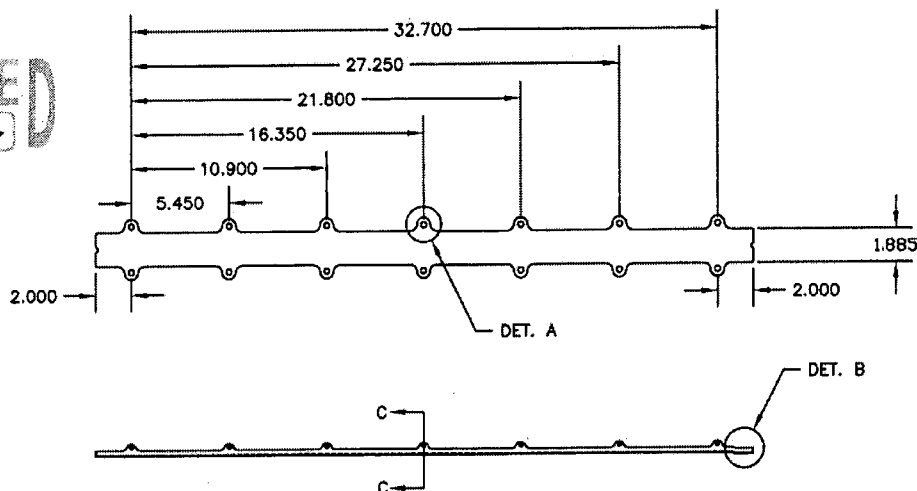
WORK ORDER
NO. 25914



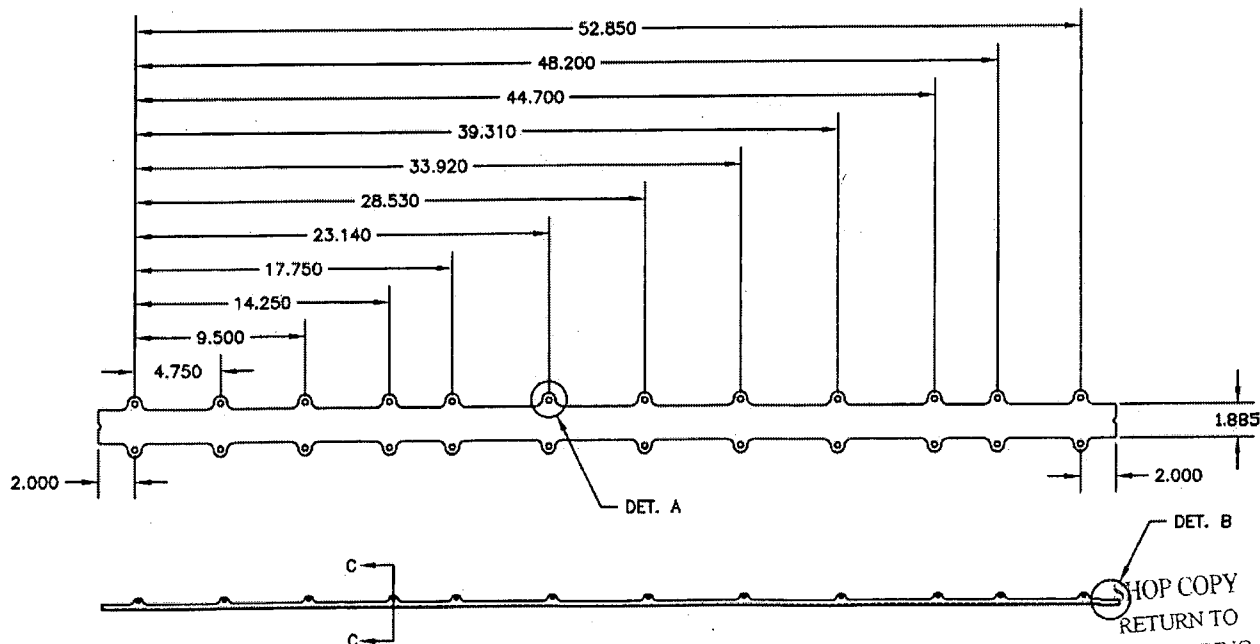
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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

RELEASED
05.07.06

D2656-21



D2656-23



NOTES

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W
SERIES STEEL, 20 GAUGE (0.040 THICK)
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

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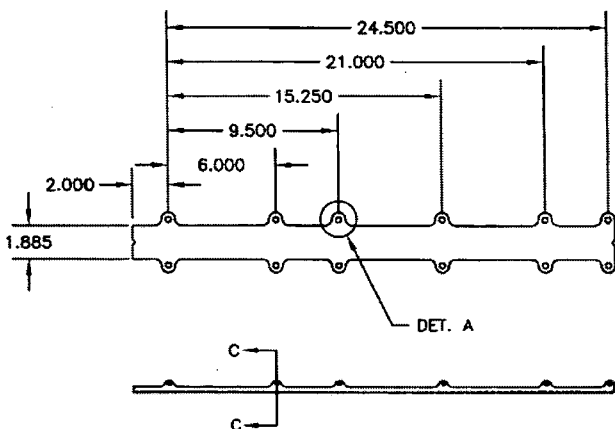
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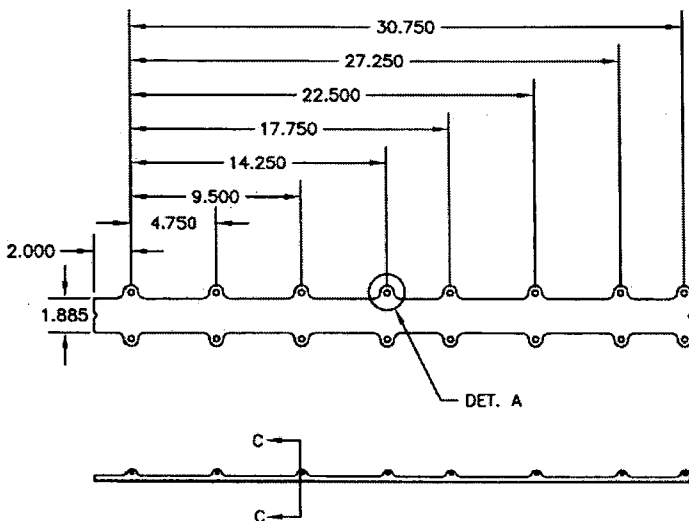
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DATE	05.08.17	TITLE	D2656	WEARSHOE
		REV. D	SHEET 3 OF 4	SCALE 1:10

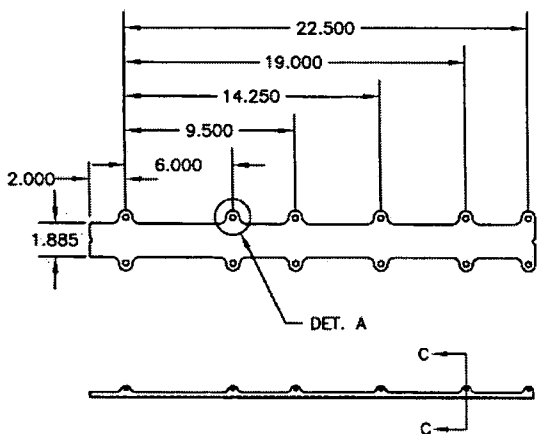
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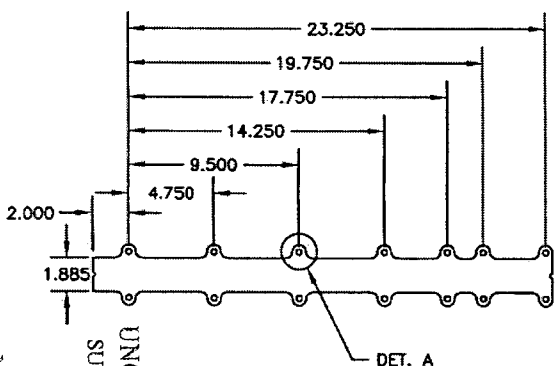
D2656-37



D2656-31



D2656-35



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05-07-06

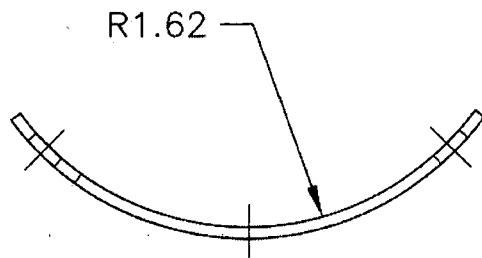
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SERIES STEEL, 20 GAUGE (0.040 THICK)
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TOLERANCES ARE PER DART QSI 018
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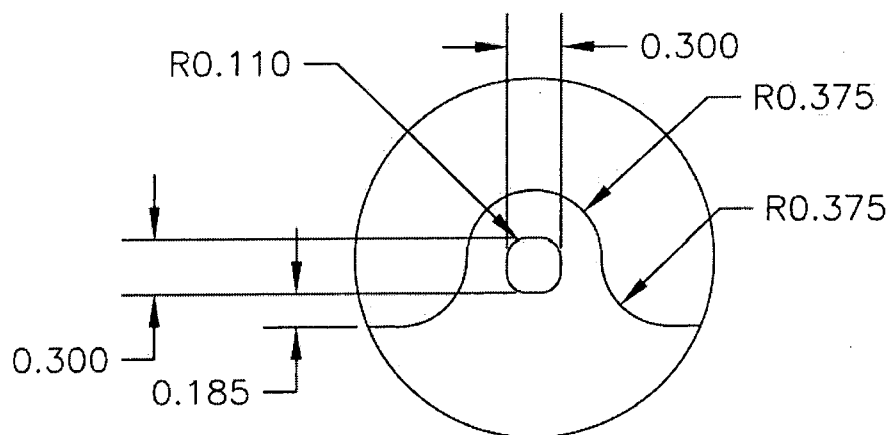
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

SECTION C-C

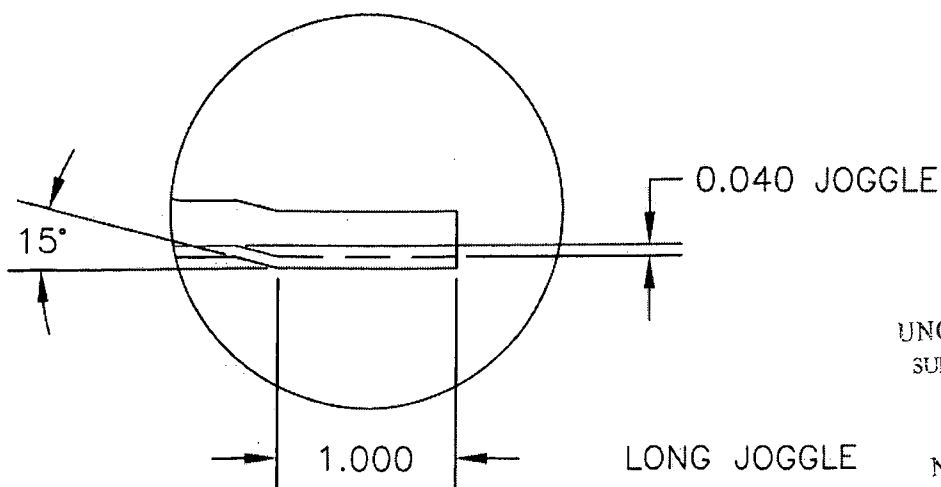


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05.09.06 *[Signature]*

DETAIL A



DETAIL B



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Glenbrook, South Auckland
Postal: Private Bag 82121, Auckland, New Zealand
Telephone: (09) 375 8988 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8859



Ref: 5746/25184

Reissued 1/12/2005

CUSTOMER	Wilkinson	SPECIFICATION	ASTM A1988 CS Type A	CERTIFICATE No	TCL22432
CUSTOMER OWN	98-21N-963	PRODUCT	CRA WIDE COIL	PAGE	1 of 1
ROLL ON	507666	DIMENSIONS	0.953" x 48" x Coil	DATE	29 November 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A378)							
		C	SI	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE()	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100				x1000										x10000	x100	180°			G.L.=	HRB	()	(feet)
R9-470783-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1532
R9-470784-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1444
R9-470785-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1558
R9-470786-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1499
R9-470787-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1558
R9-470788-00	645530	6	1	20	11	21	12	17	22	2	5	1	1					Good				53		1545
R9-470789-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				56		1558
R9-470790-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				56		1558
R9-470791-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				50		1558
R9-470792-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				50		1444
R9-470793-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				53		1558
R9-470794-00	645701	5	TR	19	11	15	12	17	23	3	8	1	1					Good				53		1444
R9-471202-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1631
R9-471203-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				57		1604
R9-471204-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				58		1604
R9-471205-00	645502	6	1	20	14	21	11	17	21	2	6	1	1					Good				58		1539

P.0659

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.657 So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=0 (C)=45 (B)=90 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
----------------------------------------------------------	----------------------------------------------------------------------------------	------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------	---------------------------------------------------------------------------------

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Atish Misra
QC METALLURGIST